

### **Abstract**

In a method of manufacturing and laying a plurality of elongate elements into an umbilical comprising a core element, a plurality of conduits of metal and if necessary at least one cable situated outside the core element, which core element is advanced along a feed line and the conduits and the cables are fed onto the outside of the core element and laid in a helix, a first group of single lengths of metal tubes forming the conduits are provided parallel one to another, the single lengths are advanced in the direction of the feed line, a second group of single lengths of metal tubes are provided parallel one to another, the lengths of the second group are advanced in the direction of the feed line and the first ends of the lengths of the second group are welded to the second end of the lengths of the first group, further groups of single lengths of metal tubes are provided and welded to the lengths of the foregoing group respective by, the metal tubes welded together are laid to the outside of the core element in the form of a helix in the same working step in which they are welded together, that the single lengths of each group are advanced into a receptacle (4a, 4b) having a tube like form, and that the receptacle is moved into the feed line and takes up said center core.

Figure to be published: figure 3